

Work Order ID 71555

Wednesday, July 06, 2011 11:58:22 AM



Item ID: D2574

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Aft In 205

Start Date: 7/6/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 4.00



Customer:

Reference:

[Handwritten signature]

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2574	Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 71555 Double check by: HA 11-Machine Step No
1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step
No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine
Step No 3 per Folio FA051 and insp

amk 11/07/11

4

[Handwritten mark]

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

amk 11/07/11

4

[Handwritten mark]

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

amk 11/07/11

4

[Handwritten mark]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71555

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

M 117745

3200F

1:15

1:45

H BR 11-7-12

4X ϕ m-l 11/07/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals: _____ **Process Plan:** _____ **Date:** _____

Tooling: _____ Date: _____

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

**Insp.
Stamp**

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 933

0.00

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

MF
11-07-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 06, 2011 11:58:19 AM

Page 1

Work Order ID: 71555

Parent Item: D2574

Parent Item Name: Saddle, Aft In 205



Start Date: 7/6/2011

Required Date: 7/15/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-005

Manufactured

No

110

Each

49.0000

1

4



Saddle Billet

Location

Loc Qty

Loc Code

MAT045

38

66966

18

70676

20

MAT046

11

~~4~~ 65382

4

65953

4

66966

3

4

OK 4/10/07/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 71555
Description: Saddle, Aft Inboard		Part Number: D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

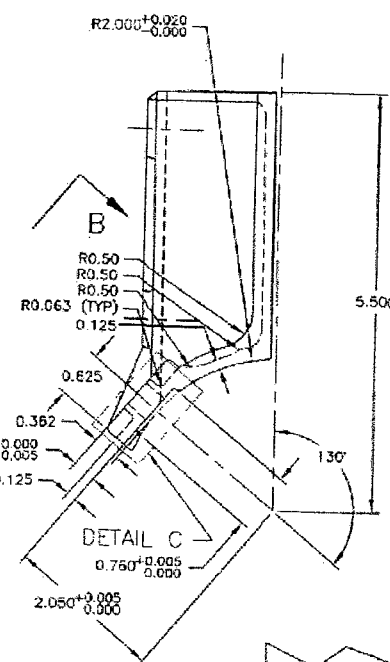
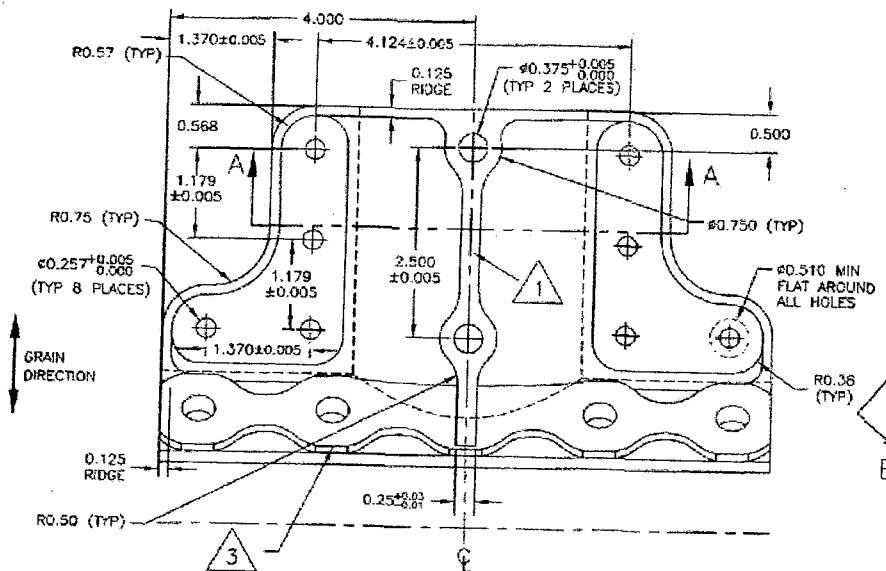
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.748	1.750	1.750	1.750		
C	3.495	3.505		3.499	3.500	3.500	3.500		
D	1.745	1.755		1.748	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.003	8.003	8.003		
F	0.490	0.510		.501	.504	.503	.504		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.501	.498	.500	.500		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		.568	.566	.567	.567		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.365	1.375		1.368	1.369	1.369	1.369		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	4.119	4.129		4.123	4.123	4.123	4.123		
P	0.115	0.135		.125	.125	.123	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.257	.249	.257	.257		
S	0.115	0.135		.127	.127	.123	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.236	3.230	3.230	3.230		
V	0.230	0.250		.236	.233	.235	.236		
W	0.115	0.135		.125	.129	.126	.126		
X	0.307	0.312		.311	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.365	.365	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.628	.628	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.243	.247	.243		
AE	1.500	1.520		1.513	1.513	1.513	1.508		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.270	.275	.275	.275		
AH	0.240	0.260		.247	.245	.248	.248		
AI	2.000	2.020		2.005	2.005	2.005	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	amf
Date:	11/07/12

Audited by:	H.A
Date:	11/07/12

Rev	Date	Change	Revised by	Approved
A		New Issue		
B	02.09.27	Re-format; Added Rev. D	RF	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ	
E	05.12.05	Added dimension AJ	KJ/RF	
			KJ/JLM	

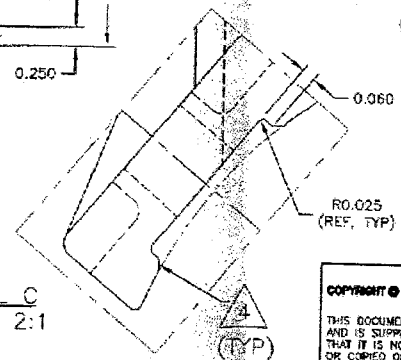
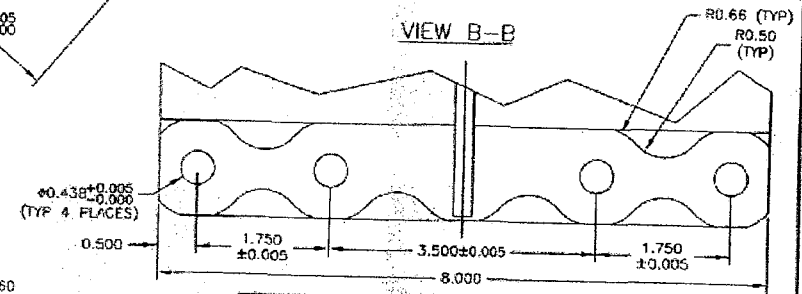
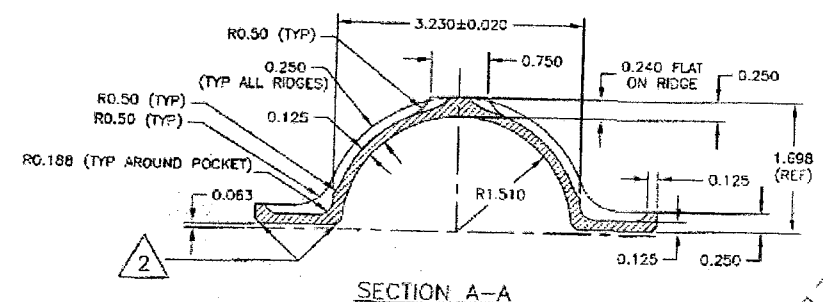
05.12.06



NOTES


MATERIAL: 7075-T7351 (Q9-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALUMINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)



DETAIL C
SCALE 2:1

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DART AEROSPACE LTD.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCPOR. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	95.09.16	NEW ISSUE
DESIGN	DRAWN BY	 DART AEROSPACE LTD. HARRISBURY, ONTARIO, CANADA
DS	PH	
CHECKED	APPROVED	DRAWING NO.
		D2574
DATE	TITLE	
05.07.13	INNER AFT SADDLE	
		SCALE
		2.3